

Date Opened: 05 December 2013

Job #: 698  
Project: Mounting Beams  
Type: Bell 206L/407

Approval: SH00-48  
Drawing List: DCL698-2, Rev. 4

Fabrication and Assembly Drawing(s)	Description
69830, Rev. 3	Forward Beam
69831, Rev. 3	Aft Beam

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: \_\_\_\_\_

Inspector Signature: \_\_\_\_\_

Date: \_\_\_\_\_

Drawing: 69830 Revision 3  
 Assembly: 69830-02 Forward Beam (Stainless)  
 Batch Quantity: 5 sets

Qty	Part #	Description	Material	P.O./W.O.	Checked
5 Total	69830-02	Forward Beam Assembly			
. 1	69830-13	Tube	304 Stainless, 1x2x0.125 tube	13077	
. 1	69830-14	Tube	304 Stainless, 1x2x0.125 tube	13077	
. 2	69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	13077	
. 1	69830-16	Strap	304 Stainless, 0.105" Sheet		
. 1	69830-17	Block	304 Stainless, 3/16" x 3/4" bar		
. 1	69830-19	Cap	321 Stainless, 0.032" Sheet		
. 1	69830-20	Cap	321 Stainless, 0.032" Sheet		
. 1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube		
. 1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod		
. 1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod		
. 1	69830-23	Spring	15mm x 70 mm Spring		
. 1	#10-32	Screw	Stainless Steel, Commercial		
. 1	MS21044C3	Nut			

Processes	Per	Mat'ls Used	Initials
Welding	AMS2685C	ER308L Rod - PO13053	
Powder Coat	Drawing 69830		
Final Inspection	Drawing 69830		

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69831 Revision 3  
 Assembly: 69831-02 Aft Beam (Stainless)  
 Batch Quantity: 5 sets

Qty	Part #	Description	Material	P.O./W.O.	Checked
6 Total	69831-02	Aft Beam Assembly			
. 1	69831-13	Tube	304 Stainless, 1x2x0.125 tube	13077	
. 1	69831-14	Tube	304 Stainless, 1x2x0.125 tube	13077	
. 1	69831-15	Tube	304 Stainless, 1x2x0.125 tube	13077	
. 2	69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube		
. 1	69830-16	Strap	304 Stainless, 0.105" Sheet		
. 1	69830-17	Block	304 Stainless, 3/16" x 3/4" bar		
. 1	69830-19	Cap	321 Stainless, 0.032" Sheet		
. 1	69830-20	Cap	321 Stainless, 0.032" Sheet		
. 1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube		
. 1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod		
. 1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod		
. 1	69830-23	Spring	15mm x 70 mm Spring		
. 1	#10-32	Screw	Stainless Steel, Commercial		
. 1	MS21044C3	Nut			

Processes	Per	Mat'ls Used	Initials
Welding	AMS2685C	ER308L Rod - PO13053	
Powder Coat	Drawing 69831		
Final Inspection	Drawing 69831		

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L1407 Mounting Beams (AFU) QTY 5

Manufacturer: AEBO Design

Part No.: 69831-02 Serial / Batch No.: PO 13077

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-57

Remaining Tasks to be Performed: Machin<sup>cs</sup> Requires doubler  
installed AD-05 AD-05 Dec 18/2013

Signature: Cuthbert

Date: Dec 6/2013 Lic. No. / ACA AD03

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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WO# 2013-57

Approved Manufacturing Facility 73-04



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 40

Manufacturer: AERO Design

Part No.: 69830-15 Serial / Batch No.: 012093

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-39

Remaining Tasks to be Performed: Weld into Beam

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\_\_\_\_\_

Signature: Cumhi Yumell

Date: Sep 13 / 2013 Lic. No. / ACA \_\_\_\_\_

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 2061407 Mounting Beams (FWD) QTY 5

Manufacturer: AERO Design

Part No.: 69830-02 Serial / Batch No.: PG 13077

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-57

Remaining Tasks to be Performed: ~~Requires doubler installed~~

~~AD-05~~ AD-05 Dec 18/2013

Signature: *Luigi Zambelli*

Date: Dec 6/2013 Lic. No. / ACA AD03

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: STRAP (1/8 304 SS)

Manufacturer: AERO DESIGN

Part No.: 69830-06 Serial / Batch No.: PO 10036 / H097 (user)

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: TBA

Remaining Tasks to be Performed: WELD TO BEAM ASSY

QTY 14

Signature: [Signature]

Date: 25 JULY 2013 Lic. No. / ACA

**In Process**



**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Remarks**

**In Process**

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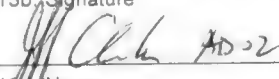
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1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-57</b>
6. Item	7. Description	8. Part Number	9 Qty.	10 Serial/Batch No.	11. Status/Work
1.	Forward Beam Assembly	69830-02	1	N/A	New
2.	Aft Beam Assembly	69831-02	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571 10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation <input type="checkbox"/> Non approved design data specified in block 12					
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del> <del>14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>20 May 2014</b>		<del>14d. Name</del> <del>14e. Date (dd/mmm/yyyy)</del>	

#### Installer Responsibilities


This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified


Statements in blocks 13a or 14a do not constitute installation certification. In all cases the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown

Summit

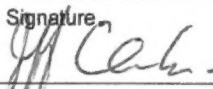


1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-57</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1	Forward Beam	69830-02	1	N/A	New	
2	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.				<del>           14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12             Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.         </del>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>29 Apr 2014</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

HELIX DYNAMICS

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-57</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1	Forward Beam	69830-02	1	N/A	New	
2	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.				<del>           14a. <input type="checkbox"/> CAR 571.10 Maintenance Release   <input type="checkbox"/> Other regulation specified in block 12             Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.         </del>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke</b>		13e. Date (dd/mmm/yyyy) <b>03 Mar 2014</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Perceps

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2013-57	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1	Forward Beam	69830-02	1	N/A	New	
2	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 27 May 2015		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

WILDERNESS





# Aero Design Ltd.

Type:

Work Order:

Task	By	Notes	Date
Weld basket body # 78411-01 to basket rim.	AD-05		Dec 12/2013
Weld basket <del>body</del> rim # 78411-01	AD-05		Dec 12/2013
Weld mesh to basket body # 78411-01.	AD-05		Dec 13/2013
Weld mesh ends to basket body # 78411-01.	AD-05		Dec 13/2013
Weld bushing # 49215-01 to basket assy. 78411-01.	AD-05	B# 2013-55	Dec 13/2013
Weld end caps to hoops of basket assy # 78411-01.	AD-05		Dec 13/2013
Weld basket <del>body</del> rim # 69811-01	AD-05		Dec 12/2013
Weld basket body to rim # 69811-01	AD-05		Dec 12/2013
Weld mesh to basket assy # 69811-01	AD-05		Dec 13/2013
Weld mesh ends to basket assy # 69811-01.	AD-05		Dec 13/2013
Weld bushing # 49215-01 to basket assy. # 69811-01.	AD-05	B# 2013-55	Dec 13/2013
Weld dia. braces and cut-out braces in place.	AD-05		Dec 13/2013
Assemble weld 5 sets of 69830-02.	AD-05	110 of 69830-11 bushings B# 2013-38 (100 of 78633-06 B# 208-29) (69830-15 bushing) 10 used (doubler 69830-06 B# 13082, 5 used)	Dec 18/2013
Assemble weld 5 sets of 69831-02.	AD-05	110 of 69830-11 bushings B# 2013-38 (69830-15 Bushing 10 used) (doubler 69830-06 B# 10036, 4 used) (doubler 69830-06 B# 13082, 1 used)	Dec 18/2013

} WO# 2013-57





Technical drawing of a mechanical assembly, likely a propeller or shaft component, showing side and end views with dimensions and callouts.

**Side View Dimensions:**

- Overall length: 28.80
- Distance from left end to center of hole 10: 0.83
- Distance from left end to center of hole 05: 0.83
- Distance from left end to center of hole 06: 41.18
- Distance from center of hole 05 to center of hole 06: 40.35
- Distance from center of hole 06 to right end: 0.3
- Distance from center of hole 06 to right end (alternative): 0.15

**End View Dimensions:**

- Overall width: 0.94
- Slot width: 0.07 (1/32) (0.406)

**Callouts and Features:**

- 01AW: 2 PLACES (at left end)
- 02AW: 2 PLACES (at center of hole 05)
- 03AW: 2 PLACES (at center of hole 06)
- 04AW: 2 PLACES (at right end)
- 05: CENTER ON SURFING (at center of hole 05)
- 06: CENTER ON SURFING (at center of hole 06)
- 07AW: 2 PLACES (at right end)
- 08AW: 2 PLACES (at right end)
- 09AW: 2 PLACES (at right end)
- 10: 2 PLACES (at left end)
- 11AW: 2 PLACES (at left end)
- 12AW: 2 PLACES (at left end)
- 13AW: 2 PLACES (at left end)
- 14AW: 2 PLACES (at left end)
- 15AW: 2 PLACES (at left end)
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- 97AW: 2 PLACES (at left end)
- 98AW: 2 PLACES (at left end)
- 99AW: 2 PLACES (at left end)
- 100AW: 2 PLACES (at left end)

**05 BUSHING**

Technical drawing of a bushing showing two views: a side view and a top view. The side view shows a rectangular part with a length of 1.08 and a diameter of  $\varnothing 0.383$  (REF). The top view shows a circular part with a diameter of  $\varnothing 0.62$  (REF).

**06 STRAP**

Technical drawing of a strap showing a side view. The strap has a total length of 4.90, a width of 1.03, and a thickness of 0.89. The ends are tapered, with a width of  $\varnothing 0.88$  at the base.

**07 BLOCK**

Technical drawing of a block showing two views: a side view and a top view. The side view shows a rectangular part with a length of 0.75 and a height of 0.18. The top view shows a square part with a side length of 0.18.

Technical drawings of four types of end mill bits:

- 09 CAP:** A simple cylindrical bit with a diameter of 0.94 inches (24 mm) and a length of 2.13 inches (54 mm).
- 10 CAP:** A bit with a 42° angle on one side. The diameter is 0.94 inches (24 mm). The length of the angled section is 1.58 inches (40 mm). The total length is 1.98 inches (50 mm).
- 11 GUIDE:** A bit with a diameter of 0.70 inches (18 mm) and a length of 1.58 inches (40 mm). It has a central hole with a diameter of 0.40 inches (10 mm).
- 12 STOP:** A bit with a diameter of 0.94 inches (24 mm) and a length of 2.13 inches (54 mm). It has a central hole with a diameter of 0.40 inches (10 mm). The bit is labeled "STOP" and "0.94" (24 mm).

Technical drawings of three parts:

- (13) KNOB:** A cross-sectional view of a knob. It has a central hole with a diameter of  $\varnothing 2 \text{ (0.100)}$ . The outer diameter is  $0.53 \pm 0.04$ . The total height is  $0.29 \pm 0.04$ . The bottom flange has a thickness of  $0.04$ . The part is labeled **(13) KNOB**.
- (14) SPRING:** A coiled spring with a wire diameter of  $0.028$ . The total length is  $2.75 \pm 0.05$ . The part is labeled **(14) SPRING**.
- (08) KNOB:** A cross-sectional view of a knob. It has a central hole with a diameter of  $\varnothing 0.100$ . The outer diameter is  $0.25$ . The total height is  $0.29 \pm 0.05$ . The bottom flange has a thickness of  $0.05$ . The part is labeled **(08) KNOB**.

Technical drawing of a cross-section of a bolt. The drawing shows a circular cross-section with a central hole. Dimensions are indicated as follows:

- Top diameter:  $\phi 0.75$  TYP
- Top hole diameter: DRILL  $5/16$  (0.312)
- Bottom hole diameter: SLOT  $\#13/32$  (0.406)
- Bottom diameter:  $0.50$  REF
- Height of the top section:  $0.75$
- Height of the bottom section:  $0.50$

[illegible]